

Work Order ID 72352

Friday, July 22, 2011 2:50:00 PM



Page 1

Item ID: D206-559-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 7/22/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 7/29/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

/

Date: 11-07-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN-D206-559

rev L

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-559-013 CHG006

Sukol25

H Cor MLS 11-10-24
(4)

160

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

SP 11-10-24

170

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

Sukol25

(4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD206-559-013 Location: 12

ReoB

SP 11-1025

(4)

190

0.00



QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

11/10/26

mf
11-10-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, July 22, 2011 2:50:06 PM

Work Order ID: 72352

Parent Item: D206-559-013

Parent Item Name: Bearpaw



Start Date: 7/22/2011




Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

Comments:

IPP Rev:J 04.02.17 Blank size changed KJ/JLM
 IPP Rev:K 07-01-02 Was K10008 JLM
 IPP Rev:L 08-01-09 Added Step 2 JLM Verified By:EC
 IPP Rev:M 08-04-29 update seq. 8 and 12 DD verified by:EC
 IPP Rev:N 08-10-15 New Manufacturing Method JLM Verified
 By:EC IPP Rev G 10.10.04 per DSI9527 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status																								
AN4-17A 		Purchased	No			160	Each	494.0000	12	48																											
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST358</td><td>300</td><td></td></tr><tr><td>116419</td><td>0</td><td></td></tr><tr><td>116704</td><td>0</td><td></td></tr><tr><td>117514</td><td>200</td><td>48x</td></tr><tr><td>117619</td><td>100</td><td></td></tr><tr><td>ST359</td><td>194</td><td></td></tr><tr><td>116704</td><td>194</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST358	300		116419	0		116704	0		117514	200	48x	117619	100		ST359	194		116704	194	
Location	Loc Qty	Loc Code																																			
ST358	300																																				
116419	0																																				
116704	0																																				
117514	200	48x																																			
117619	100																																				
ST359	194																																				
116704	194																																				
AN4-20A 		Purchased	No			160	Each	576.0000	12	48																											
<table><tr><th>Location</th><th>Loc Qty</th><th>Loc Code</th></tr><tr><td>ST359</td><td>576</td><td></td></tr><tr><td>115936</td><td>76</td><td></td></tr><tr><td>116419</td><td>200</td><td>48x</td></tr><tr><td>117514</td><td>300</td><td></td></tr></table>														Location	Loc Qty	Loc Code	ST359	576		115936	76		116419	200	48x	117514	300										
Location	Loc Qty	Loc Code																																			
ST359	576																																				
115936	76																																				
116419	200	48x																																			
117514	300																																				
AN960JD416 	NAS1149D0463J	Purchased	No			160	Each	0.0000	24	96																											

~~119042~~
m 119042

SP 11-10-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Page 2

Friday, July 22, 2011 2:50:06 PM

Work Order ID: 72352

Parent Item: D206-559-013

Parent Item Name: Bearpaw

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

D2182B Manufactured No

160 f

192.7852 2.5 10



Rubber Cushion



SP

Location

Loc Qty

Loc Code

ST410

192.78517

66063

192.78517

10

(D2182B050) cut qty (6) at 5.00% as per dwg ***per kit***

D2274 Manufactured No

160 Each

475.0000 12 48



Radius Block



SP

Location

Loc Qty

Loc Code

ST010

475

68942

175

69736

200

69773

100

3x

D2432 Manufactured No

160 Each

0.0000 2 8



206 (24") Bearpaw



74492

D2438 Manufactured No

160 Each

301.0000 6 24



Clamp



B73400 SP

Location

Loc Qty

Loc Code

ST456

301

67830

22

68673

81

69737

108

70693

90

11-10-24

Friday, July 22, 2011 2:50:07 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Friday, July 22, 2011 2:50:07 PM

Work Order ID: 72352

Parent Item: D206-559-013

Parent Item Name: Bearpaw

Start Date: 7/22/2011

Required Date: 7/29/2011

Start Qty: 4.00

Required Qty: 4.00

D2529

Manufactured No

160 Each

565.0000

12

48



Washer



B73486 SP

Location

Loc Qty

Loc Code

ST016

565

66953

315

71161

250

D2732

Manufactured No

160 f

664.8981

2.5

10



Rubber Extrusion



B73759 .10X

SP 11-10-24

Location

Loc Qty

Loc Code

ST410

664.89811

64283

166.02811

70987

498.87

(D2732-050) cut qty (6) at 5.00" as per dwg ***per kit***

MS21042L4

Purchased No

160 Each

3,673.000

12

48



Nut



M118451

SP 11-1024

Location

Loc Qty

Loc Code

ST300

3673

117441

1426

117601

747

117885

1500

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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REFERENCE ONLY

5.0 PARTS LIST

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			16	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
						8	D3456-1	WASHER
					2		D3859-041	WEARPLATE
				2			D3860-041	WEARPLATE
						8	D4011-1	CLAMP, SHORT
						8	D4011-5	CLAMP, SHORT (OEM)
						8	D4012-1	CUSHION
						2	D4355-1	BEARPAW
						2	D4360-041	WEARPLATE ASSEMBLY
						8	AN4C11A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT
						16	AN4C20A	BOLT
						16	AN4C21A	BOLT
16	24	16	24	8	12	16	NAS1149D0463J	WASHER (OR AN960JD416)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						24	MS21043-4	NUT
2		2					QS200M44S	CLAMP